

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019256**Date Inspected:** 27-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

OBG Seg 13AW:

Notification no: 007514.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) SEG3013B-170
- 2) SEG3013F-005, 007

OBG Seg 13CE:

Notification no: 007514.

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC QC

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personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) SEG3011C-257
- 2) SEG3011E-069
- 3) SEG3011G-069
- 4) SEG3011J-069
- 5) SEG3011C-065
- 6) SEG3011E-065
- 7) SEG3011C-094, 098, 102, 106, 110, 114, 118, 122, 126, 130, 134, 138, 142, 146, 150, 154, 158, 164, 168, 172, 176.

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

This QA Inspector observed that the fit-up of X4442 and X4445 Web-plates with Floor beams (FB) FB3189 [at panel point (PP) 119], FB3193 (at PP119 + 1500) and FB3186 (at PP119 – 1500) is completed. However, it was observed that the paint on the I-rib stiffeners on the Floor Beams were not removed before the fit-up is done. This is informed to ZPMC CWI, identified as Li Ming Yang. ZPMC agreed that the paint at the weld area on the I-rib stiffeners will be removed before welding is done. See attached photos for further details.

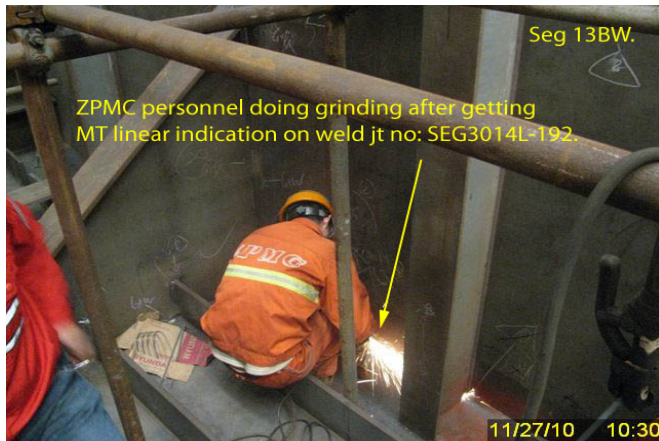
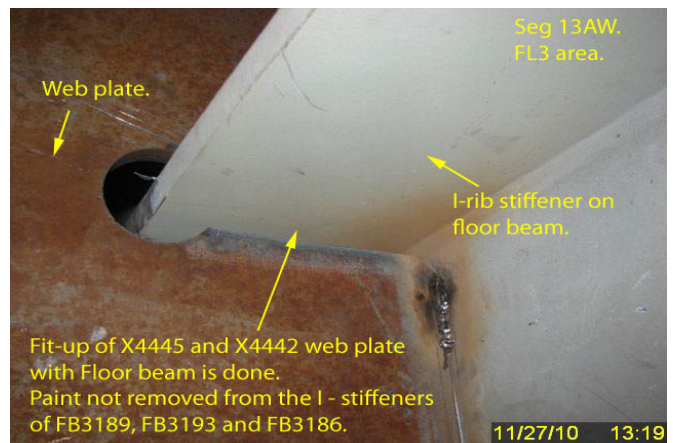
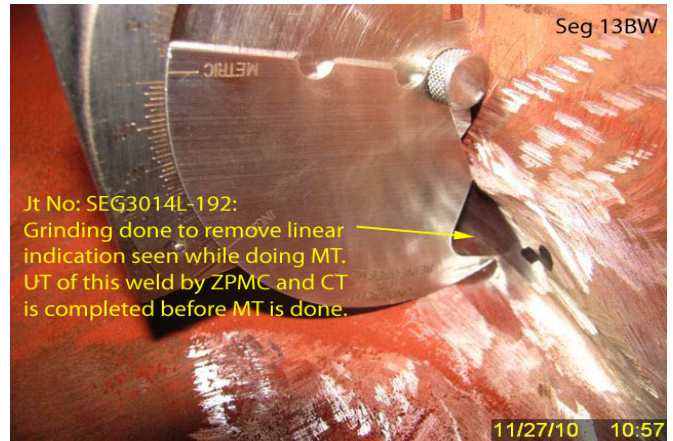
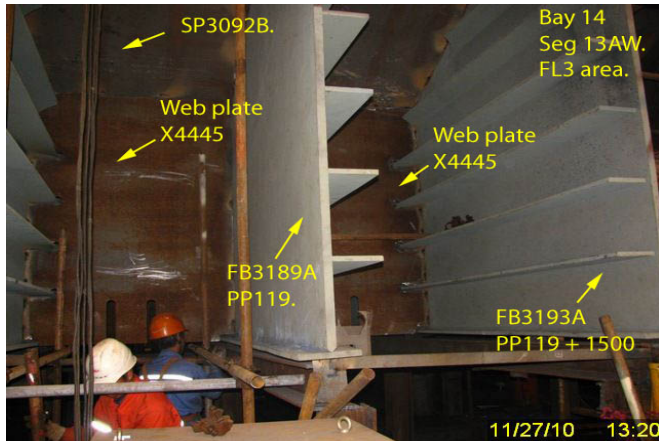
OBG Seg 13BW:

This QA Inspector observed ZPMC personnel doing Magnetic Particle testing (MT) of Longitudinal Diaphragm (LD) to Bottom Panel (BP) from PP120.5 to PP124.5. UT of these welds by ZPMC and CT is already done. However, while performing MT, on weld jt no: SEG3014L-192, transverse indications were observed. Grinding of this weld was needed to be done for the removal of these indications. ZPMC QC, identified as Qiu Wen, agreed to do the repair welding at this location after having proper Critical Welding Report (CWR). See attached photos for further details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer